

Date: Wednesday, 2/15/2006 3:50:15 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)  
 Job Number : 25859  
 Estimate Number : 10530  
 P.O. Number : N/A Part Number : D2571  
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2571 REV DE  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : DE  
 Previous Run : 25829 Material : NA  
 Due Date : 3/12/2006 Qty: 6 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : JF 06.02.16  
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: B24093

x 6

Ep 06/03/15

(6)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. B25857 Double check by: J.L

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

Ep 06/03/15

06/03/15 6

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

Ep 06/03/15

06/03/15 6

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ep 06/03/15

06/03/15 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:15 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25859

Part Number: D2571

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.03.26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.m 06-03-27 (6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/28 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 4/3/29 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 478

DL 4/3/29 (6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/03/30 (6)

Job Completion



DL 06/03/29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 25859
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1

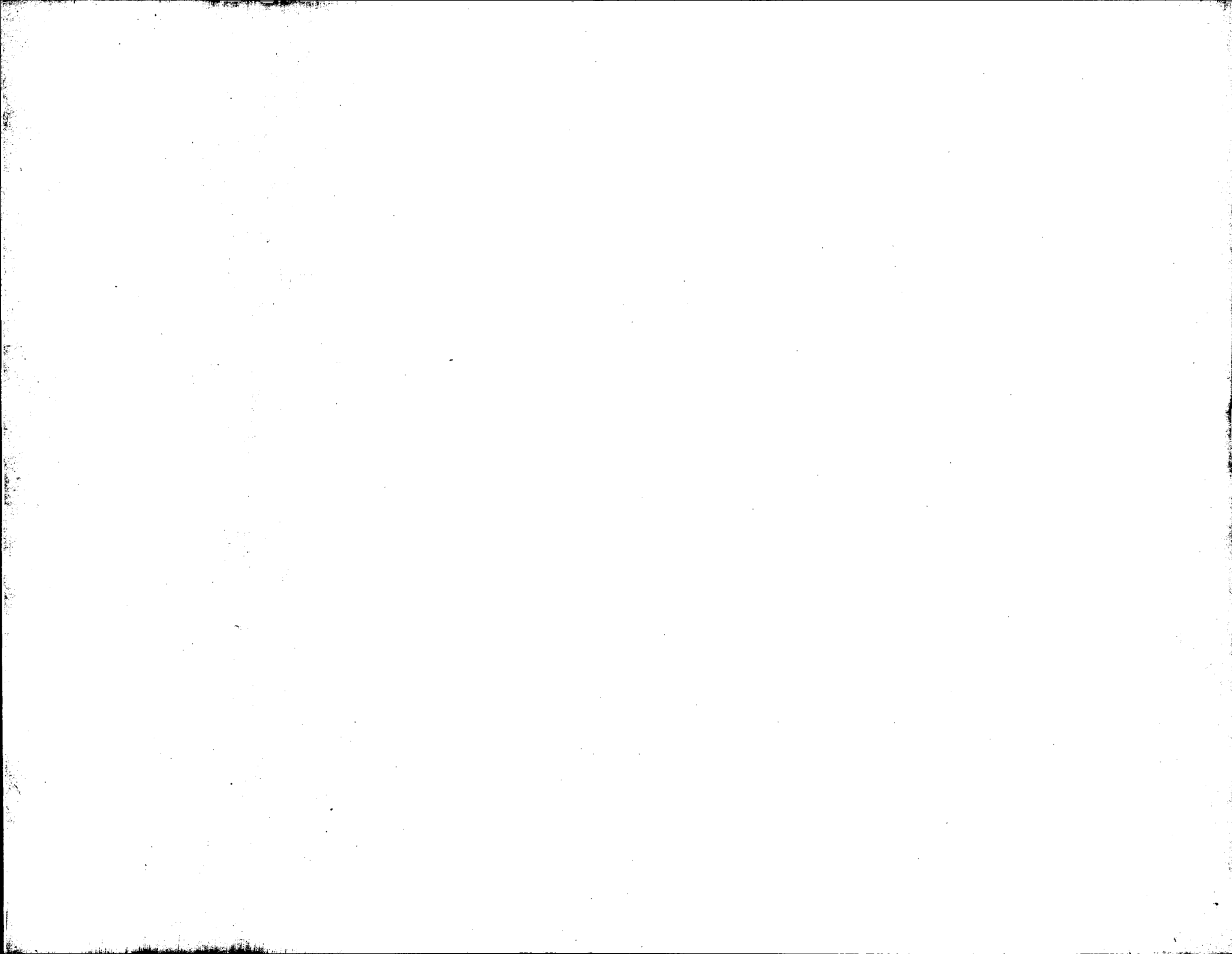
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.746	1.746	1.745		
C	3.495	3.505		3.496	3.497	3.496	3.497		
D	1.745	1.755		1.745	1.746	1.746	1.745		
E	7.990	8.010		8.004	8.005	8.006	8.005		
F	0.490	0.510		0.492	0.493	0.493	0.493		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.501	0.502	0.501		
J	1.174	1.184		1.177	1.178	1.178	1.177		
K	0.558	0.578		0.564	0.563	0.563	0.566		
L	1.174	1.184		1.177	1.178	1.178	1.177		
M	1.490	1.500		1.494	1.494	1.494	1.496		
N	2.495	2.505		2.495	2.495	2.496	2.495		
O	3.869	3.879		3.871	3.876	3.874	3.872		
P	0.115	0.135		0.128	0.128	0.128	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.253	0.252	0.254	0.251		
S	0.115	0.135		0.126	0.125	0.125	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.245	0.245	0.245		
W	0.115	0.135		0.120	0.118	0.118	0.119		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.356	0.355	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.625	0.628	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.256	0.256	0.251	0.251		
AE	1.375	1.395		1.385	1.386	1.386	1.384		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.249	0.251	0.255		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	En
Date:	06/03/24

Audited by:	SA
Date:	06.03.26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>25859</b>
<b>Description: Saddle, Fwd Outboard</b>	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg: D2571 Rev. E</b>		<b>Page 1 of 1</b>


Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438				
B	1.745	1.755		1.745	1.747				
C	3.495	3.505		3.496	3.497				
D	1.745	1.755		1.745	1.746				
E	7.990	8.010		8.006	8.005				
F	0.490	0.510		0.500	0.501				
G	0.257	0.262	DT8683	0.257	0.257				
H	0.375	0.380	DT8684	0.375	0.375				
I	0.490	0.510		0.498	0.499				
J	1.174	1.184		1.178	1.179				
K	0.558	0.578		0.566	0.567				
L	1.174	1.184		1.178	1.179				
M	1.490	1.500		1.494	1.494				
N	2.495	2.505		2.498	2.499				
O	3.869	3.879		3.873	3.874				
P	0.115	0.135		0.128	0.127				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.252	0.252				
S	0.115	0.135		0.125	0.124				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.245	0.244				
W	0.115	0.135		0.118	0.118				
X	0.308	0.313		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.366	0.360				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.625	0.627				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.252	0.252				
AE	1.375	1.395		1.386	1.386				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.254	0.254				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		0.030	0.030				
Accept/Reject									

Measured by:	En
Date:	06/03/25

Audited by:	SD
Date:	06.03.26




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06 

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.063" x 45° ALL AROUND
5. CHAMFER 0.033" x 45° (SEE DETAIL C)



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE LTD.</b> HARRISBURG, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO.
		D2571
DATE	TITLE	
05.07.13	OUTER FWD SADDLE	
		SCALE
		2:1

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DETAIL C  
SCALE 4:3

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NO. 25859